

Work Order ID 91274

91274

Page 1

October-05-12 9:15:53 AM

Item ID: 647.4716

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Spacer

Stop *NS2*

Start Date: 10/05/12 Start Qty: 15.00

15

Cust Item ID:

Required Date: 10/31/12 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12-10-05

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.4700	N/C

110

0.00

110

Waterjet

Memo

0.00

FEOW CNC Waterjet

2024.063

1-Cut as per Dwg
Dwg Rev: N/C
Prog Rev: N/C

2-Deburr if necessary

15 0 Im 12-10-14

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

15 0 Im 12-10-14

Work Order ID 91274

91274

Page 2

October-05-12 9:15:53 AM

Item ID: 647.4716 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacer
 Start Date: 10/05/12 Start Qty: 15.00 ***15*** Cust Item ID:
 Required Date: 10/31/12 Req'd Qty: 15.00 ***15*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		3mb 12/10/15		15			
140 *140* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	0.00 0.00		2/10.18/53					62 12/10/17 (15)
150 *150* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.00							64 4/1/7 (15)

91274

October-05-12 9:15:53 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 10/05/12 **Start Qty:** 15.00 ***15***

Cust Item ID:

Required Date: 10/31/12 **Req'd Qty:** 15.00 ***15***

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

0.00

170

SprayPaint

Memo

0,00

Spray Painting

PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)

CARDINAL 4860-50 PRIMER BATCH: 122543

180

QC14- Inspect Spray Paint

0.00

180

QC

Memo

0.00

Quality Control

Work Order ID 91274

91274

October-05-12 9:15:53 AM

Item ID: 647.4716 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Spacer
 Start Date: 10/05/12 Start Qty: 15.00 *15* Cust Item ID:
 Required Date: 10/31/12 Req'd Qty: 15.00 *15* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: 439	0.00							
190									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

12/14/2015

12/11/22

ME
12-11-21

Picklist Print

October-05-12 9:15:52 AM

Page 1

Work Order ID: 91274

Parent Item: 647.4716

Parent Item Name: Spacer

Start Date: 10/05/12

Required Date: 10/31/12

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV:A 12.09.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063

2024-T3 .063 sheet

Purchased

No

110

sf

122.4200

0.068

10736842

1.1

Jan 12-10-14

Location

Loc Qty

Loc Code

MAT022

122.42

119916

10.1

121197

16.32

123096

96

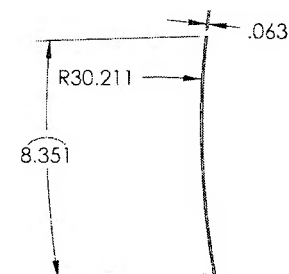
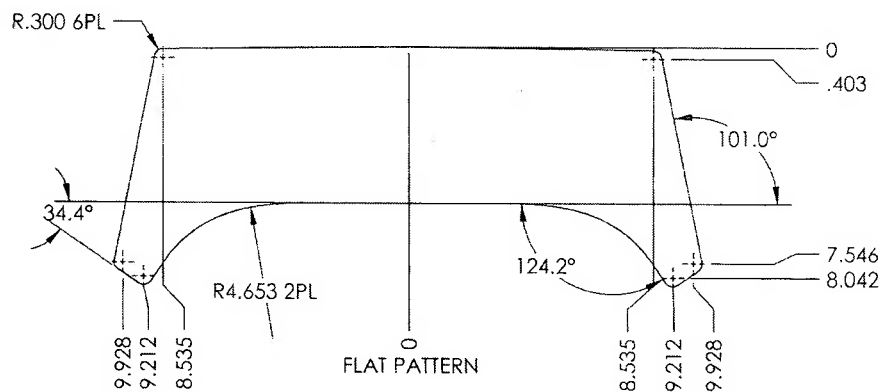
123096

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NOTES: UNLESS OTHERWISE SPECIFIED

1. MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
1	1401 REWORK TYPE REVISED PER		MMT
2	2001 RELEASE	10-13-07	P. BRADY



647.4711

SHOP COPY
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WORK ORDER

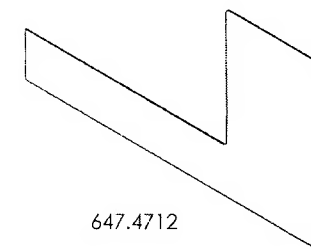
NO. 91274 MCT
12-10-05

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	1	647.4718	CLIP AFT RH	△	△
	1	647.4717	CLIP AFT LH	△	△
	1	647.4716	SPACER	△	△
	1	647.4715	CLIP RH	△	△
	1	647.4714	CLIP LH	△	△
	1	647.4713	BRACKET	△	△
	1	647.4712	DOUBLER	△	△
	1	647.4711	DOUBLER	△	△
		PART #	DESCRIPTION	MAT'L	SPEC.
QTY			PARTS LIST		
NEXT ASSY (S)			APICAL INDUSTRIES		
647.2600			2608 TEMPLE HEIGHTS DR.		
			OCEANSIDE, CA. 92056-3512 (760)724-5300		
			SHEETMETAL		
			UNLESS OTHERWISE SPECIFIED		
			DIMENSIONS ARE IN INCHES		
			TOLERANCES ARE:		
			FRACTIONS DECIMALS ANGLES		
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			1/32 0.0312 1.0 0.001 0.001 0.001		
			1/64 0.0156 1.0 0.001 0.001 0.001		
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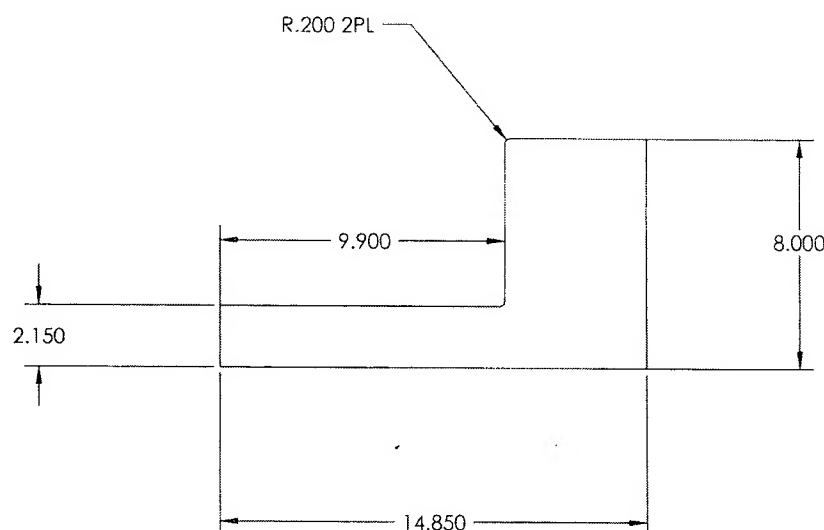
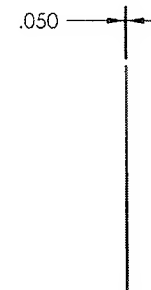
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REVISION			
REV	DESCRIPTION	DATE	APPROVED

91274



647.4712



ORIGINAL DATE 04/01/01		REVISED DATE 05/11/05	
DESIGNED BY A. CHART		CHECKED BY D. BARLES	
DRAWING APPROVED BY E. BRADY		CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS INCHES ANGLES ± 3°		REV. CODE CODE	REV. NO.
8 07M16		647.4700	N/C
SCALE 1:1		SHEET 2 OF 7	

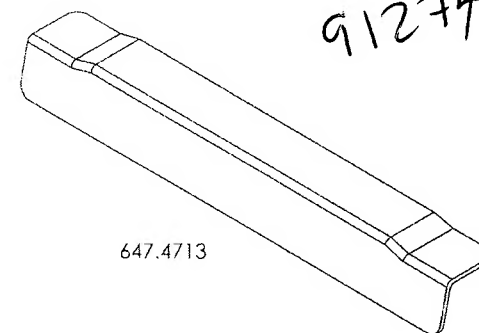
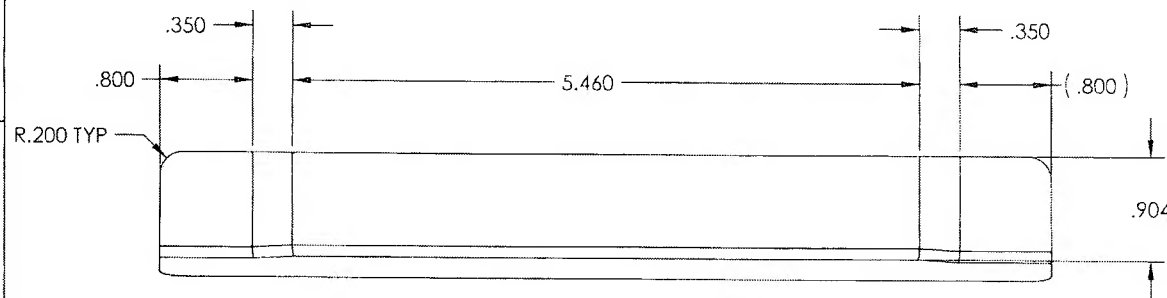
APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

SHEETMETAL

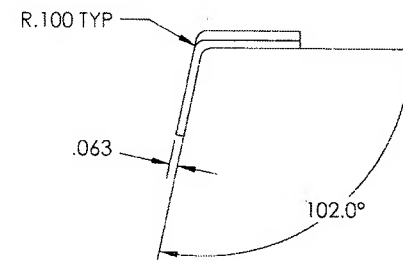
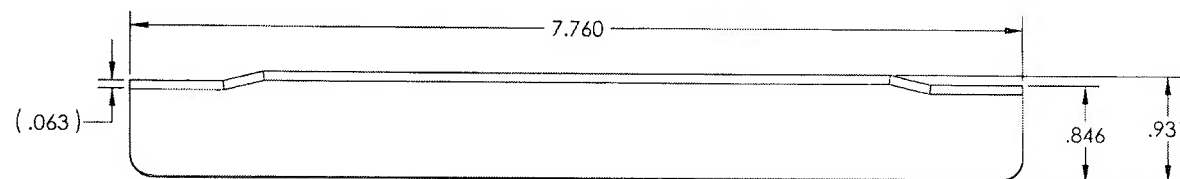
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REV	DESCRIPTION	DATE	APPROVED

91274



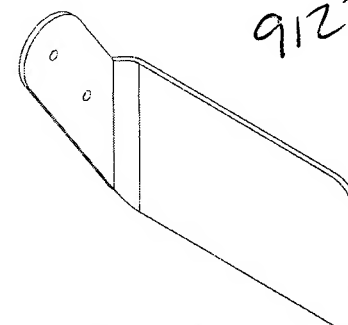
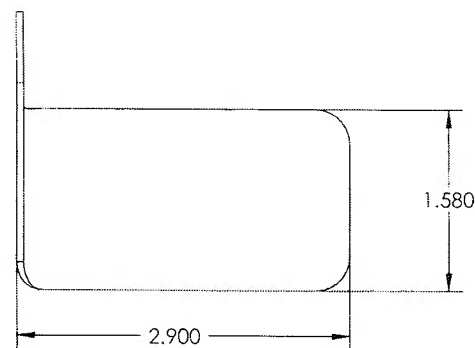
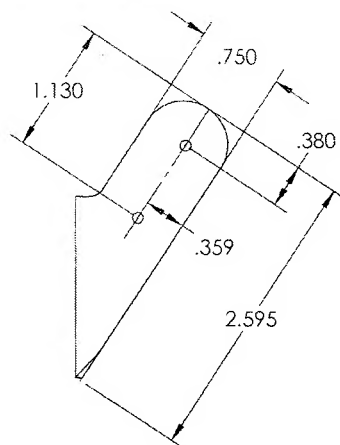
647.4713



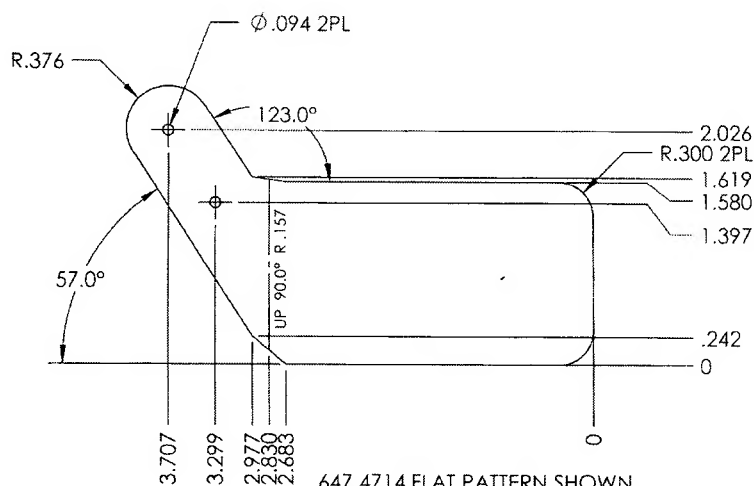
DESIGNED BY: [blank] CHECKED BY: [blank] DRAWING APPROVAL: [blank] CONTRACT NO: [blank]	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 1 PLACE DECIMALS ±.01	SHEETMETAL REV: [blank] SCALE: NONE SHEET: 3 OF 7

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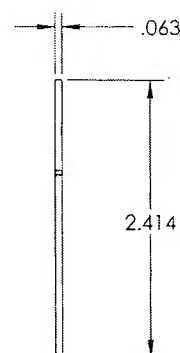
REV	DESCRIPTION	DATE	APPROVED



647.4714 SHOWN
647.4715 OPPOSITE



647.4714 FLAT PATTERN SHOWN
647.4715 BEND DOWN



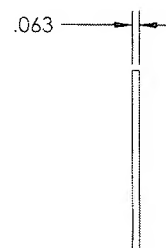
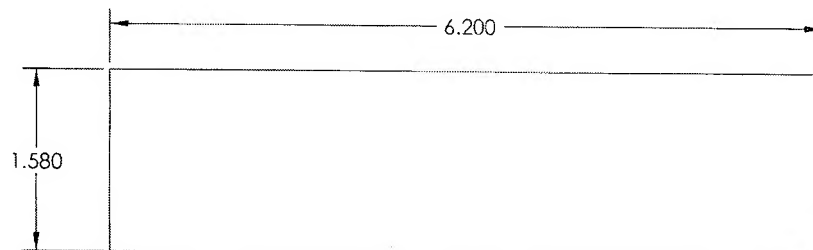
APICAL INDUSTRIES	
2608 TEMPLE HEIGHTS DR.	
OCEANSIDE, CA. 92056-3512 (760) 724-5300	
SHEETMETAL	
DATE	07/26/26
BY	07/26/26
SCALE	NONE
SHEET	4 OF 7

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THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REV.	DESCRIPTION	DATE	APPROVED

91274

647.4716

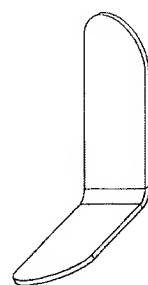
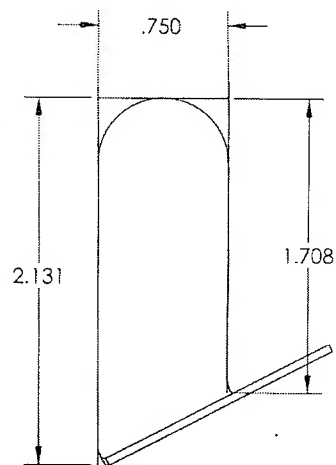


ORIGINAL DATE 10/10/00 DRAWN BY: J. S. S. S. A. CHAN: J. S. S. S. DRAWING APPROVAL: J. S. S. S. CHECKED BY: J. S. S. S.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300 SHEETMETAL
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS ARE 3 PLACE DECIMALS 1/16" 2 PLACE DECIMALS 1/32" ANGLES 1/2°	SHEET 647.4700 SCALE: NONE SHEET 5 OF 7

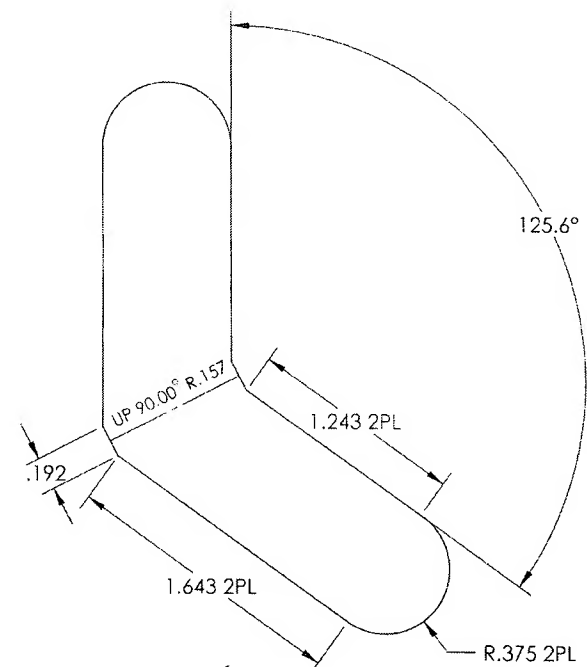
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REVISION			
REV	DESCRIPTION	DATE	APPROVED

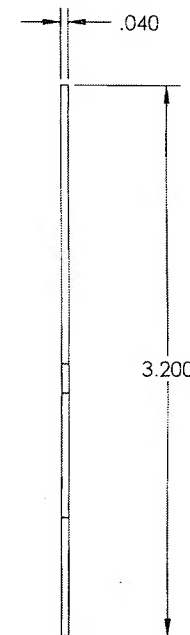
91274



647.4719



647.4719 FLAT PATTERN



ORIGINAL DATE (DD/M/YY)	10/11/07	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300		
DRAWN BY:	J. QUINN			
CHECKED BY:	D. BARBER			
DESIGN APPROVAL				
DATE:	07/11/07	SHEETMETAL		
UNLESS OTHERWISE SPECIFIED				
DIMENSIONS ARE IN INCHES				
TOLERANCES ARE:				
FRACTIONS	DECIMALS .001	SIZE GRADE CODE QWTS. REQ. REV. 8 07M126 647.4700 N/C SCALE: NONE SHEET 7 OF 7		
ANGLES	DECIMALS .001			
HOLE:	2.0			



A.T.G. Industries Inc.
 731, rue Industrielle Rd.
 PLATING DEPARTMENT
 Rockland, On K4K 1T2
 Canada
 Ph: (613) 446-4544
 Fax: (613) 446-4556

Pack List

Number: 62027

Date: 05-Nov-12

To

DART AEROSPACE LTD
 1270 ABERDEEN ST.
 HAWKESBURY, ON K6A 1K7
 Canada

Ship To

DART AEROSPACE LTD
 1270 ABERDEEN ST.
 HAWKESBURY, ON K6A 1K7
 Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: ASST 10 PCS 646.9813 10 PCS 646.9811 10 PCS 646.9812 10 PCS 646.9812 2 PCS 646.9811 15 PCS 646.4711 15 PCS 647.4716 15 PCS 647.4712 15 PCS 647.4717 15 PCS 647.4714 15 PCS 647.4715 15 PCS 647.4718 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120674	Rev:	PO: PO18153 Line:
1 lot	Part: ASST 7 PCS 647.1810 14 PCS 647.1811 91 PCS 647.1812 2 PCS 647.1612 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120673	Rev:	PO: PO18304 Line:
Certificate of Conformance			



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

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Date: 05-Nov-12

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Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via
Quantity	Description	
	A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.	
	ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY	
	DATE: <u>5/12/12</u>	
	CERTIFIED SIGNATURE: <u><i>mw</i></u>	
	RECEIVER SIGNATURE: _____	